

Date: Friday, 12/21/2007 7:27:15 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI ACCESS HANDLE WELDMENT ASS'Y, LH
Job Number	: 36509		
Estimate Number	: 10946		
P.O. Number	:	Part Number	: D2480011
This Issue	: 12/21/2007 S.O. No. :	Drawing Number	: D2480 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: A1
Previous Run	: 34014	Material	:
Written By	:	Due Date	: 1/10/2008 Qty: 4 Um: Each
Checked & Approved By	: <u>12/21</u>		
Comment	: Est. B1 03.01.09 added Powder Coat		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2478	Lower Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Lower Arm

Pick:

Qty	Part number	Description	Batch
1	D2478	Heli Access Handle	<u>B36531</u>

FC 08 02 04 (4)

2.0	D2479	Upper Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Upper Arm

Pick:

Qty	Part number	Description	Batch
1	D2479	Heli Access Handle	<u>B36532</u>

FC 08 02 04 (4)

3.0	D2481	Lower Mount Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Lower Mount Plate

Pick:

Qty	Part number	Description	Batch
2	D2481	Mounting Plate	<u>B23503</u>

FC 08 02 04 (4)

4.0	D2482	Upper Mount Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Upper Mount Plate

Pick:

Qty	Part number	Description	Batch
1	D2482	Mounting Plate	<u>B23504</u>

FC 08 02 04 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/02/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS HANDLE WELDMENT ASS'Y, LH

Job Number: 36509

Part Number: D2480011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Template DT 8333 (DT 2480 CJ)

FC 08 02 04 (21)

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08-02-04 (4)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/04 (4)

8.0

POWDER COATING

POWDER COATING



M 106379



(4X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M-1 08/02/05

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/02/05

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP 36472

08/02/05 (4)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

08/02/08

Job Completion



08/02/05 (4)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

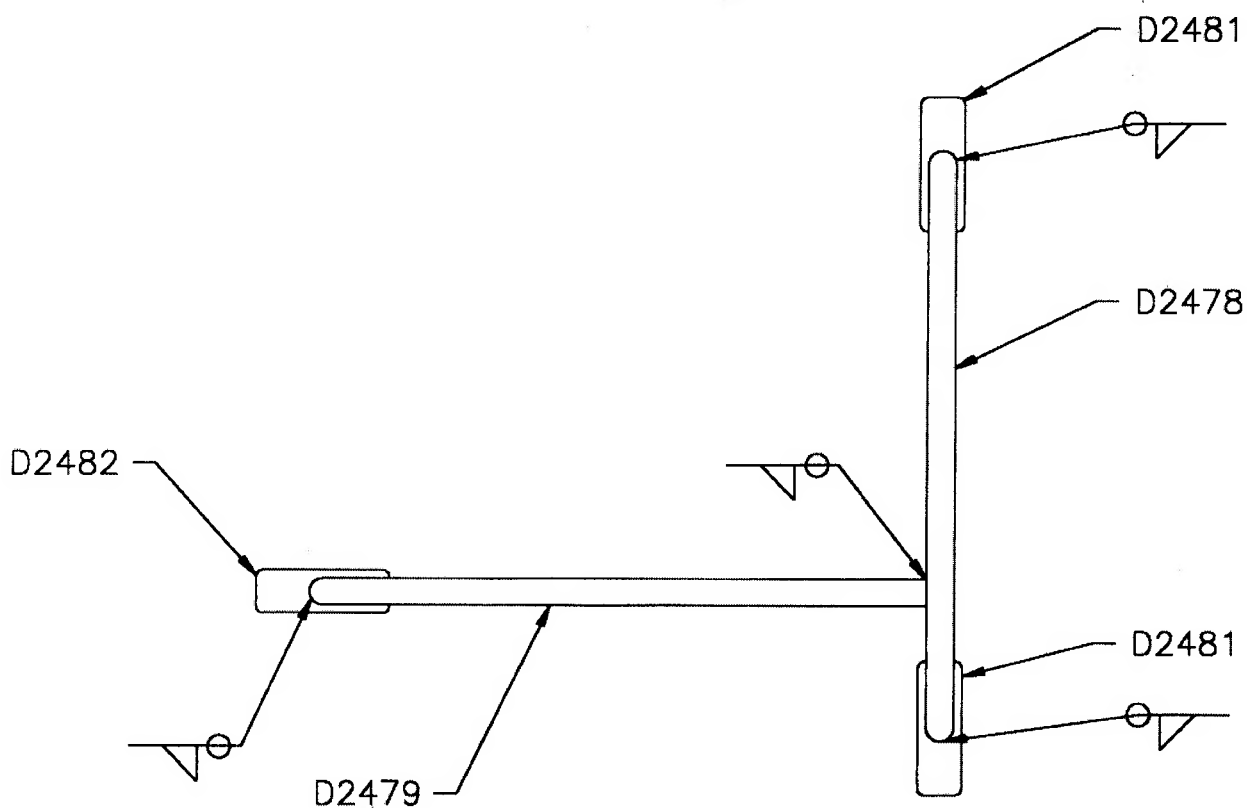
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	MIKE M	DRAWING NO.	REV. A
CHECKED <i>BW</i>	APPROVED <i>BW</i>	D2480	SHEET 1 OF 1
DATE	TITLE	SCALE	
96:05:14	HANDLE WELDMENT ASSEMBLY	6:1	
A1	05.06.23	ADDED POWDER COAT	

RELEASED
96/10/02 DS



D2480-011 LH SHOWN
D2480-012 RH OPPOSITE

NOTES:

- 1) WELD PER TEMPLATE DT 2480 WG PER QSI 004
A1 2) POWDER COAT WHITE GLOSS (REF: 4.3.5.2) AS PER QSI 005

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36509